

Work Order ID 166395

Tuesday, September 19, 2017 3:43:58 PM

166395

Page 1

Item ID: D2013-5 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Mirror Bracket LH, 204
Start Date: 9/19/2017 Start Qty: 2.00 ***2*** Cust Item ID:
Required Date: 9/25/2017 Req'd Qty: 2.00 ***2*** Customer:
Reference:

Approvals: Process Plan: dep Date: SEP 19 2017 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2013	Rev C								

100

0.00

100

NC BRAKE

Brake NC

Memo

0.63

Brake NC

1-Punch as per template D2013-T5 and Dwg D2013
2-Flatten ends of D2013-5 tube as per Dwg D2013 using DT8545 3-Bend (1)
tube as per Dwg D2013 using Jig DT8201
Identify as D2013-5.
4-Deburr as required

2 SEP 20 2017 MIC

110

QC5- Inspect part completeness to step on W/O

0.00

110

QC

Memo

0.04

Quality Control

2 SEP 21 2017 9:59

DAS
9
9:59
DAS
19
9:59

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☒ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☒ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : <u>17-09-27</u>		Step #: <u>100</u>		QTY Effective : <u>①</u>		MRB (QSI042) Approval DAS 9 9-80 17-09-27	
Description Work Order Deviation				Disposition			
<u>D203-5 was bend in wrong orientation</u>				<u>Scrap destroy replace.</u>			
				Completed By <u>HL 17-09-27</u>			
				Lead hand / Supervisor Approval Verification <u>SB 17/09/27</u>			
				QC / QA Coordinator Approval DAS 9 9-80 17-09-27			
Root Cause		FAULT CATEGORY					
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	☒ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence		
Design ☐	☒ Operator	Bending ☐	Set-up ☐	Folio/Program ☐			
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐			
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐			
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐			
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐			
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐			
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐			
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐			
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐			
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____					
Misidentified ☐	Past Due ☐						

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Tuesday, September 19, 2017 3:43:58 PM

166395

Page 2

Item ID: D2013-5

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Mirror Bracket LH, 204

Start Date: 9/19/2017 Start Qty: 2.00

2

Cust Item ID:

Required Date: 9/25/2017 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

Identify as per dwg & Stock Location: _____

0.00

120

Packaging

Memo

0.02

Packaging

LOCATION: WA001

2  SEP 21 2017 

130

QC21- Final Inspection - Work Order Release

0.00

130

QC

Memo

0.20

Quality Control

  SEP 28 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐					
OTHER : ☐									

Picklist Print

Tuesday, September 19, 2017 3:43:57 PM

Page 1

Work Order ID: 166395

166395

Parent Item: D2013-5

D2013-5

Parent Item Name: Mirror Bracket LH, 204

Start Date: 9/19/2017

Required Date: 9/25/2017

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A New Issue 05-11-01 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TR0.750W.049		Purchased			No	100	f	69.3570	1.73	3.642105			
M304TR0 750W 049									**			SEP 20 2017	<i>mlc</i>
304 RD Tube .750 x .049W													

Location

Loc Qty

Loc Code

GA002

69.3569922

M135709

0.0000037

M136943

0.000158

M137091

0.0065145

M137286

6.307316

M137477

2.549

M137623

1.042

M137761

7.852

M138403

51.6

3.65

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabelled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

Work Order Summary

Thursday, September 28, 2017 11:26:18 AM

Page 1 of 1

Criteria : Work Order ID: 166395 Item ID: D2013-5 Product Family SMALL FAB
Work Order Start Dates 9/19/2017 to 9/19/2017 11:59:59 PM Work Order Required Dates 9/25/2017 to 9/25/2017 11:59:59 PM
All References
Work Order Status Released

Work Order ID 166395 Required Qty 2.0000 Status Code Released
Item ID D2013-5 Accepted Qty 0.0000 Scrap Qty 0.0000
Item Name Mirror Bracket LH, 204
Current Acct Value \$41.372

Start Date 9/19/2017 Required Date 9/25/2017 Completed Date

Standard	** Actual **	** Acct. Value **	** Variance **	** Variance % **
Direct Costs	Total	Each	Each	Each
Material	\$7.665	\$0.000	\$3.408	\$3.408 100.00%
Labor	\$26.875	\$0.000	\$10.807	\$10.807 100.00%
Outplant	\$0.000	\$0.000	\$0.000	\$0.000 0.00%
Variable Burden	\$0.000	\$0.000	\$0.000	\$0.000 0.00%
Fixed Burden	\$54.550	\$0.000	\$27.157	\$27.157 100.00%
Material Burden	\$0.000	\$0.000	\$0.000	\$0.000 0.00%
** Total **	\$89.090	\$0.000	\$41.372	\$41.372

Item ID/Item Name	Required Qty	Issue Code	Issue Date	Issued Qty	Cost Amount
M304TR0.750W.049 304 RD Tube .750 x .049W	3.6421		9/20/2017	3.6500	\$7.665
Total Matl Amts:					\$7.665

Work Center Brake NC

Employee ID	Rout Seq ID	Labor Date	Setup Hours	Actual Setup Hours	Labor Hours	Actual Labor Hours	Nbr of WOs	Setup Amount	Labor Amount	Fix Burd Amount	Var Burd Amount	Total Amounts
LECL01		9/20/2017										
100			0.00	0.00	0.58	0.58	1.00	\$0.000	\$12.541	\$25.455	\$0.000	\$37.996
100			0.00	0.00	0.67	0.67	1.00	\$0.000	\$14.334	\$29.095	\$0.000	\$43.429
Total:			0.00	0.00	1.25	1.25	2.00	\$0.000	\$26.875	\$54.550	\$0.000	\$81.425